

Date: Tuesday, 19/08/2008 4:03:44 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RADIUS BLOCK  
 Job Number : 41422  
 Estimate Number : 10822  
 P.O. Number :  
 This Issue : 19/08/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D2274  
 First Issue : / / Type : MACHINED PARTS Drawing Number : D2274 REV F  
 Previous Run : 39238 Drawing Revision : F  
 Material :  
 Due Date : 20/09/2008 Qty: 500 Um: Each  
 Written By :  
 Checked & Approved By : Jul 08.8.19  
 Comment : Est. H 00.05.18 Added inspection level 8 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0750X00125 6061-T6 Bar .750 x .125



Comment: Qty.: 0.0962 f(s)/Unit Total: 48.0900 f(s) 1.5772 Not enough mat in comp Not taken out of comp  
 6061-T6 Bar .75" x .125"

Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch M107482

mmx  
08/08/31

2.0 SHEAR SHEAR



Comment: SHEAR

- Shear blanks 9.00" long +/- 0.030"  
 Note: 1 blank makes 9 pieces

mmx 08/08/31

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2274

20 08/09/11

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/09/11

(506)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

20 08/09/11 (506)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: RADIUS BLOCK

Job Number: 41422

Part Number: D2274

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

Deburr any rough edges after tumbling

*counted!*  
*EP 08/10/07* (506)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*M 08/10/07* (506x)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*08-10-07* (506x)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 24*

*AS 08/10/08 x 506*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/10/08*

Job Completion



*h 08.10.08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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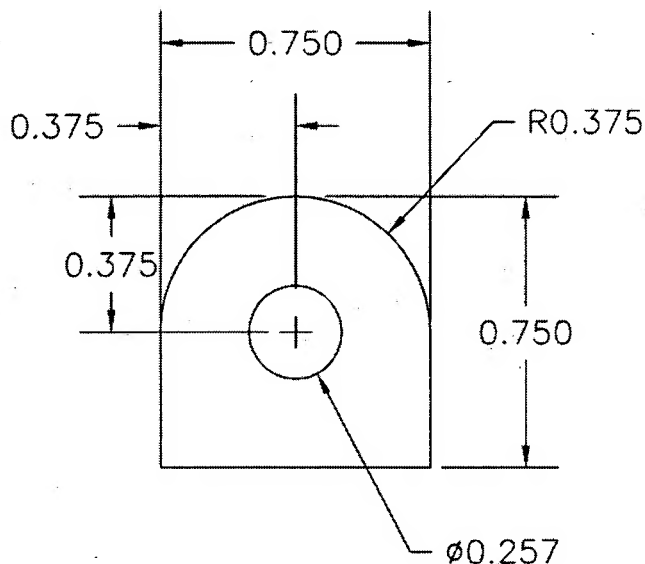
**NOTE:** Date & initial all entries





DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11	TITLE RADIUS BLOCK		SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED  
98/08/19 KE



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK  
OR 6061-T6 (QQ-A-250/11) 0.125 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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WITHOUT NOTICE  
WORK ORDER  
NO. 414

